

**Work Order ID 71801**

Page 1

Tuesday, July 12, 2011 10:06:44 AM

Item ID: D117-762-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:                     Date: 11-8-11Tooling:                     Date:                     

Run Start

QC:                     Date:                     SPC (Y/N):                     Date:                     

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3492

C

D3582

Rev-A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile &amp; type labels per PPP D117-762-041 CHG001

N/A                     

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3,  
use bending aid DT9632  
2- cut fwd end of tube as per dwg1 8 BEU/07/12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
	1-Cut Aft end using DT8185								
	2-Deburr ends								
	3-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***								
	4-Locate DT 8973 & Drill Ground wire hole on top of Tube.								
	5-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.								
	6-Drill pilot holes for wearplates using DT8900								
	7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.								
	8- open ground wear holes to 0.391" as per section B-B								
	9-Open Aft Cap holes using .209" drill.								
	10-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.								

*DL 11/07/14*

*DL 11/07/14*

W/O:		WORK ORDER CHANGES					
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  Skidtubes	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Weld fwd cap D2964 per dwg D3582 and QSI 004 A/R AL ROD Batch: <i>m112860/m115770</i> 2-Grind flush <i>BE 11/07/14</i>								
150  QC	QC10- Inspect visual per QSI004- ground welds	0.00							
Quality Control	Memo	0.00							
160  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 3B 11/07/18

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 BE 11/07/19

W/O:		WORK ORDER CHANGES					
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Accept



Setup Start



Revision ID:

Stop



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Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open X-Bolt holes to finish size as per Dwg D3582, all sections								
	2-Counter Sink X-BOLT holes as per Dwg D3582								
	3-Deburr and blow out chips from inside of tube, prep. tube for welding.								
	4-Bond web as per Dwg D3582 & QSI 015								
	A/R 241 Sike Flex Batch: <u>19 117516</u>								
	Exp Date: <u>12/01/15</u>								
	5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.								
	A/R AL ROD Batch: <u>1712060</u>								
	6-Grind welds flush								
200	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									

OK 11/07/19.

OK 11/07/20

OK 11/07/20

11.07.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				<u>11</u>	<u>11</u>	<u>07</u>	<u>22</u> (1)
215  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo Touch-up alodine as per QSI	0.00  0.00				<u>1</u>	<u>0</u>	<u>11</u>	<u>11-04-23</u>
220  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <u>1117745</u> Memo START TIME <u>10:30</u> OVEN TEMPERATURE: <u>300°</u> FINISH TIME: <u>11:00</u>	0.00  0.00				<u>1</u>	<u>0</u>	<u>11-7-25</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

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Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

260



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11 07 28 ①

270



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D117-762-041

Location:

PPP Rev:

PN 71789

11/12/28 C

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/17/29

1107-28  
G

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries









*Tuesday, July 12, 2011 10:06:51 AM*

[illegible]**Required Date:** 7/18/2011

**Required Qty: 1.00**

**Comments:** IPP Rev:A 07.06.11 New Issue EC  
IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-11 		Manufactured	No			250	Each	14.0000	2	2			
Plug												11/07/27	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP				14		B7B63		X2	
					70410			2					
					71028			12					
D3492-13 		Manufactured	No			250	Each	40.0000	6	6			
Plug												11/07/27	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP				20					
					71211			20					
				FP-13				5					
					71211			5					
				FP-B				15		B7B48		X6	
					46693			15					
D3492-9 		Manufactured	No			250	Each	41.0000	2	2			
Plug												11/07/27	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP-A				41					
					46694			41				X2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 71801

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 7/12/2011



Required Date: 7/18/2011

Start Qty: 1.00



Required Qty: 1.00

D2962-150      Manufactured      No      Each      80.0000      1  
  
 3.540 Outer Tube, Extrut  
 BE11/07/12



Location	Loc Qty	Loc Code
HALL	80	
28672	7	
59934	73	

D2964      Manufactured      No      140      Each      19.0000      1      1  
  
 Cap  
 BE11/07/14

Location	Loc Qty	Loc Code
LG002	19	
14101	5	
64654	14	

D2971      Manufactured      No      190      Each      14.0000      1      1  
  
 Cross Bolt Spacer  
 BE11/07/20

Location	Loc Qty	Loc Code
LG001	14	
44445	14	

D3584-1      Manufactured      No      190      Each      4.0000      1      1  
  
 Web  
 DL

Location	Loc Qty	Loc Code
LG	4	
71143	4	

70953

6

11/07/19.

Tuesday, July 12, 2011 10:06:51 AM

Shop Packet Print

Page 2

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 7/12/2011

Required Date: 7/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2973 Manufactured No 190 Each 128.0000 2 2



Cross Bolt Spacer



BB 11/07/20

Location

Loc Qty

Loc Code

LG002

128

14636

128

2

D3662-3 Manufactured No 190 Each 15.0000 1 1



Crossbolt Spacer



BB 11/07/20

Location

Loc Qty

Loc Code

LG001

15

44456

15

1

D3662-1 Manufactured No 190 Each 1.0000 3 3



Crossbolt Spacer



BB 11/07/20  
B 72258 \* 3

Location

Loc Qty

Loc Code

LG001

1

64451

1

36

ALS4-1032-130 Purchased No Each 2,406.000 36



Insert



11/07/27

Location

Loc Qty

Loc Code

ST281

8

117331

8

ST282

2398

117717

654

118237

1744

1118386

X36

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Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 7/12/2011

Required Date: 7/18/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-428-165

Purchased

No

Each

517.0000

2



Handwritten: 11/07/27

Inserts

Location

Loc Qty

Loc Code

FP

486

117769

486

Handwritten: X2

FP-B

31

114172

31

D2965

Manufactured

No

250

Each

22.0000

1

1



Handwritten: 11/07/27

Cap, 105 Skidtube

Location

Loc Qty

Loc Code

FP006

22

52057

22

Handwritten: X1

D3508-3

Manufactured

No

250

Each

15.0000

1

1



Handwritten: 11/07/27

Wearplate

Location

Loc Qty

Loc Code

FP021

15

38527

1

71210

14

Handwritten: X1

D3508-9

Manufactured

No

250

Each

8.0000

1

1



Handwritten: 11/07/27

Wearplate

Location

Loc Qty

Loc Code

FP021

8

70307

8

Handwritten: X1

Tuesday, July 12, 2011 10:06:52 AM

Shop Packet Print

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Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 7/12/2011

Required Date: 7/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3508-13 Manufactured No

250

Each

1.0000

1

1



Wearplate



all 11/07/23

Location

Loc Qty

Loc Code

FP016

1

65191

1

1371027

yl

AN960JD10L NAS1149D0332J Purchased No

250

Each

0.0000

2

2



Washer

1117087



x2 all 11/07/23

AN3C4A Purchased No

250

Each

1,796.000

28

28



all 11/07/23

BOLT

Location

Loc Qty

Loc Code

ST350

1796

117313

2

117688

732

117795

500

x28

117872

22

118012

500

118112

40

AN3C5A Purchased No

250

Each

1,255.000

2

2



all 11/07/23

Bolt

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1248

116419

28

116549

42

117343

500

117764

300

117872

378

x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 7

Tuesday, July 12, 2011 10:06:52 AM

Work Order ID: 71801

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 7/12/2011

Required Date: 7/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD416L NAS1149D0416J Purchased

No

250

Each

19.0000

2

2



Washer

1118131



(x2) JEL 11/02/27

Location

Loc Qty

Loc Code

FP-B

17

110153

17

ST298

2

110153

2

AN960C10L NAS1149C0332 Purchased

No

250

Each

0.0000

28

28



washer

1118306



(x28) JEL 11/07/27

AN4-4A Purchased

No

250

Each

86.0000

2

2



Bolt



JEL 11/07/27

Location

Loc Qty

Loc Code

FP-B

40

114615

40

ST356

46

114615

46

NAS1611-012 Purchased

No

250

Each

38.0000

6

6



O-RING



JEL 11/07/27

Location

Loc Qty

Loc Code

FP-A

38

113845

38

1118384

x6

Tuesday, July 12, 2011 10:06:53 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, July 12, 2011 10:06:53 AM

Work Order ID: 71801

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 7/12/2011

Required Date: 7/18/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-015

Purchased

No

250

Each

89.0000

2

2



all 7/12/11

O-RING

Location

Loc Qty

Loc Code

FP-A

89

115101

85

116081

4

x2

NAS1611-016

Purchased

No

250

Each

100.0000

2

2



all 7/12/11

O-RING

Location

Loc Qty

Loc Code

FP-A

100

112492

58

113524

42

x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

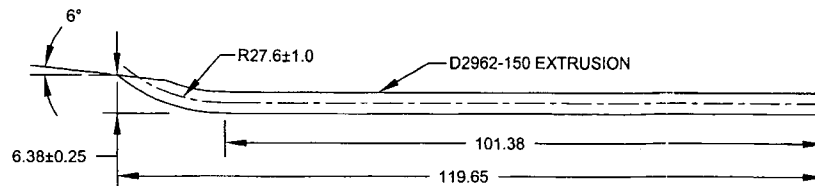


# PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

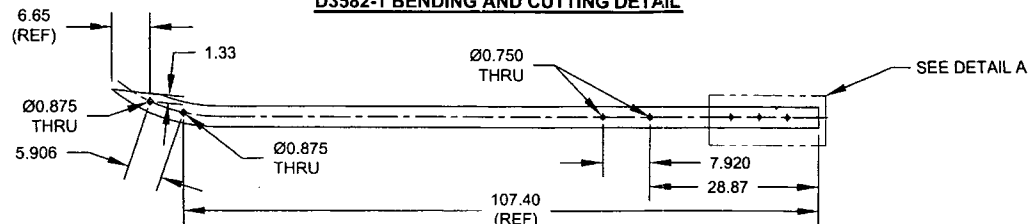
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

## GENERAL NOTES:

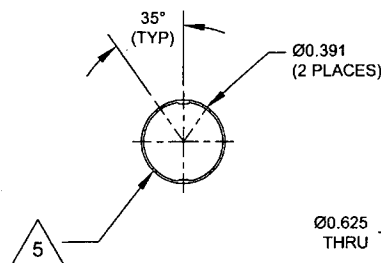
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004.
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
  - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
  - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
  - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



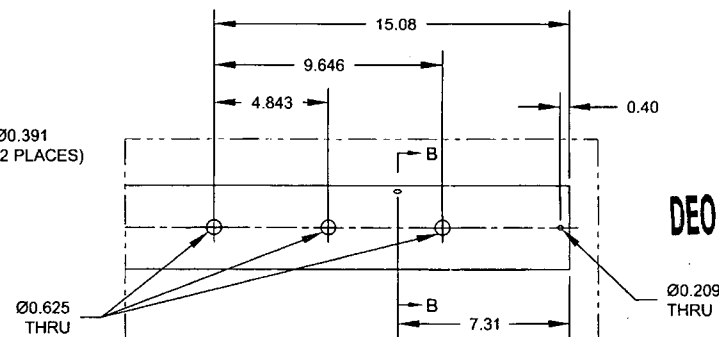
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B  
SCALE 1:5



DETAIL A  
SCALE 1:5

DEO ATTACHED

RELEASED  
67.11.22 JMD

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71801

A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	24		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.06.08		

**DART AEROSPACE USA, INC**  
PORT HADLOCK, WA

DRAWING NO. D3582  
REV. A  
SHEET 1 OF 2

TITLE BK 117 SKIDTUBE ASSEMBLY  
SCALE 1:20

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11-08-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

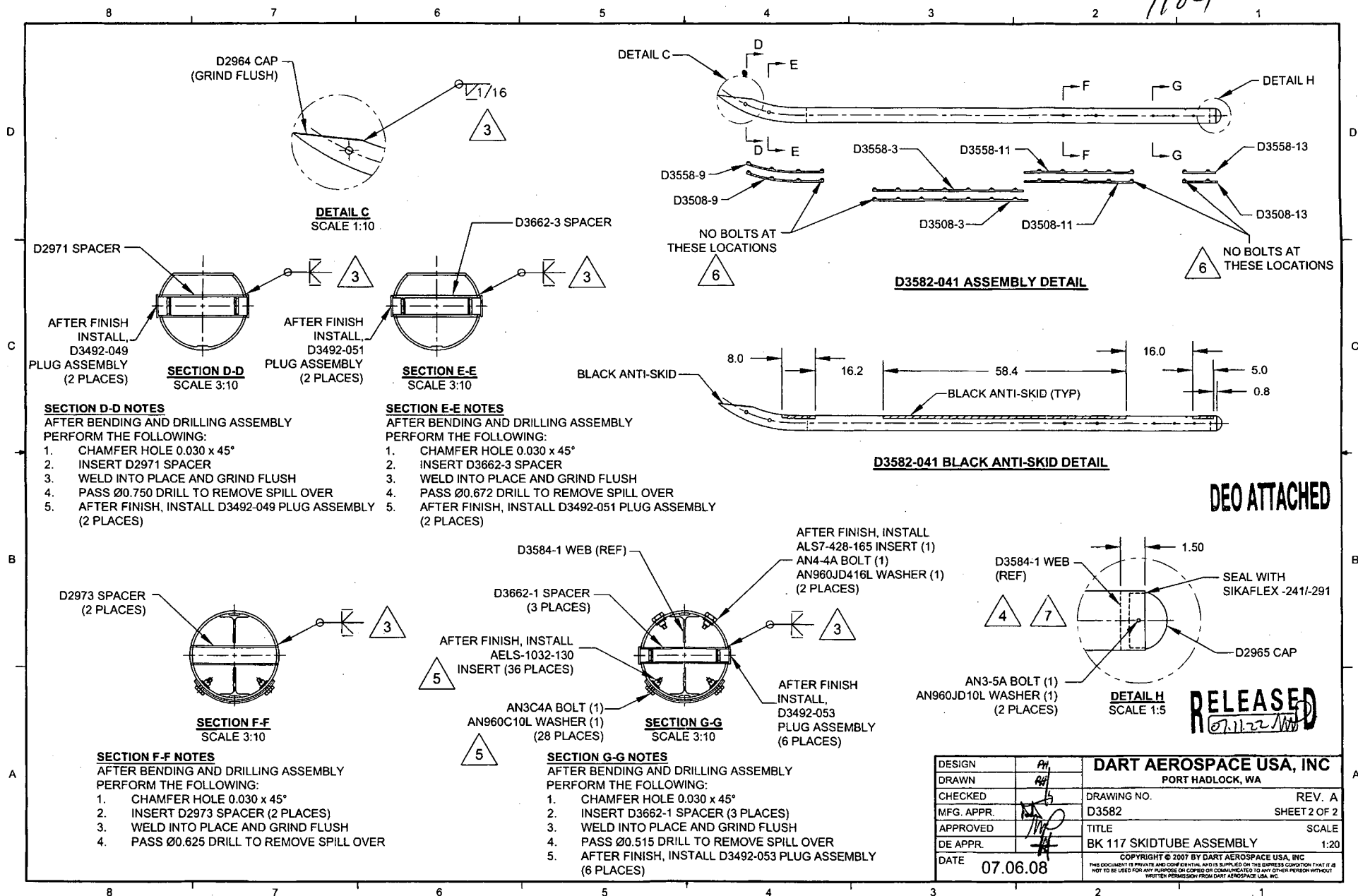
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

7189



DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3582	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BK 117 SKIDTUBE ASSEMBLY	1:20
DATE	07.06.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

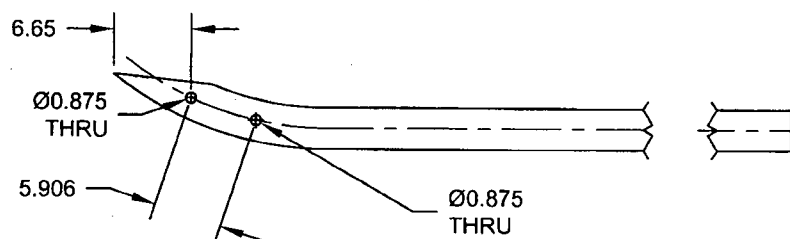
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

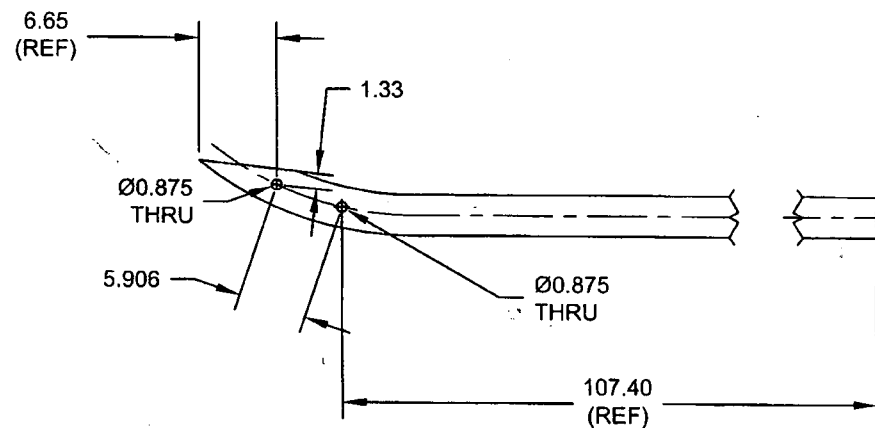
DRAWING NO. D3582	TITLE BK 117 SKIDTUBE ASSEMBLY	REV. A	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3582-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>PH</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.06	DATE 04.04.06	DATE 09.04.06	DATE 19/04/06		DATE 09.04.06		

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR:  
UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



**RELEASED**  
09/04/22 *[Signature]*

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3.452  
3.427

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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